

Date: Monday, 04/02/2008 1:30:58 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 37189	Part Number	: D36621
Estimate Number	: 13154	Drawing Number	: D3662 REV U/R
P.O. Number	:	Project Number	: N/A
This Issue	: 04/02/2008 S.O. No. :	Drawing Revision	: U/R
Prsht Rev.	: NC	Material	:
First Issue	: // Type : MACHINED PARTS	Due Date	: 11/02/2008
Previous Run	:	Qty:	20 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est A 08.02.04 Now turned on Cobra EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0625W049	6061-T6 Tube .625 x.049W
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Comment: Qty.: 0.3255 f(s)/Unit Total: 6.5100 f(s)
 6061-T6 Tube .6250 x.049W
 Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)
 Batch M 606015

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Machine as per Folio FA

J.F. 08/02/05 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/02/05 (20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/02/05 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 4/G DP 8-2-5

(20)

POSITIVE RECALL

EFFECTIVE 08/02/04 AUTH URELEASED 08/02/04 DATE U

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/02/2008 1:30:58 PM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 37189

Part Number: D36621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/09

Job Completion



2008/2/06

(20)

W

Dart Aerospace Ltd

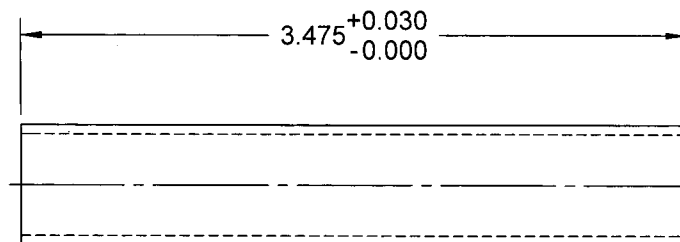
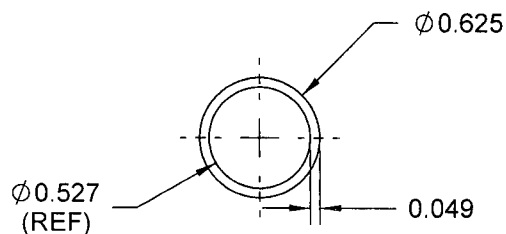
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

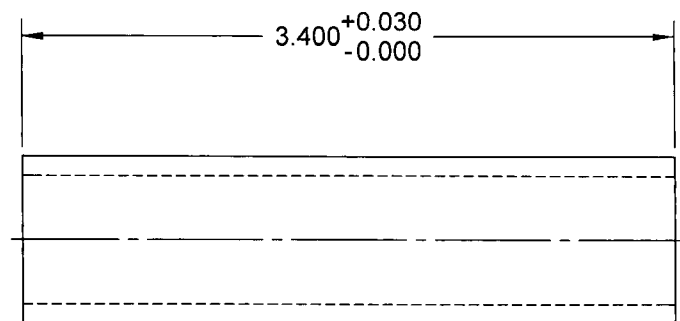
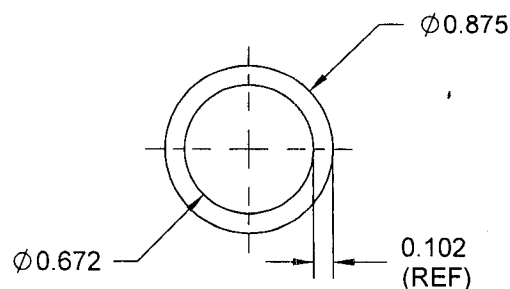
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3662-1 CROSS BOLT SPACER



D3662-3 CROSS BOLT SPACER

NOTES:

1) MATERIAL:

D3662-1 - ALUMINUM 6061-T6/T62
TUBING PER WW-T-700/6 OR AMS 4080/4082
OR QQ-A-200/8 OR QQ-A-225/8.

(REF. DART MATERIAL SPEC. M6061T6T0.625W0.49)
D3662-3 - ALUMINUM 6061-T6 (OR 6061-T651/T6510/T6511/T62)
ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART MATERIAL SPEC. M6061T6RX.XXX)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

**7) WEIGHT: D3662-1 - 0.03 LBS
D3662-3 - 0.08 LBS**

PRELIMINARY ISSUE

A	NEW ISSUE	PH	07.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3662	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CROSS BOLT SPACER	1:1
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

L Lacelle

From: Peter Hum [phum@dartaero.com]
Sent: February 7, 2008 9:18 AM
To: 'L Lacelle'
Subject: RE: D3662-1/-3

Yes you can sign off the positive recall

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: February 7, 2008 9:10 AM
To: 'Peter Hum'
Subject: RE: D3662-1/-3

[illegible]

From: Peter Hum [mailto:phum@dartaero.com]
Sent: February 7, 2008 9:04 AM
To: 'L Lacelle'
Subject: RE: D3662-1/-3

They will be used once we get the STC.

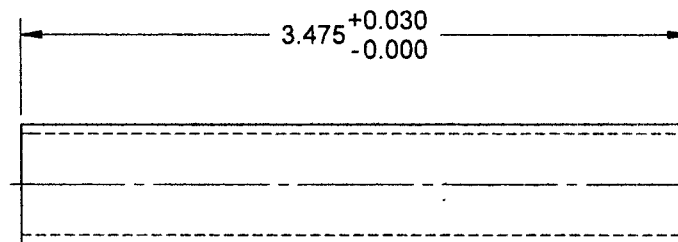
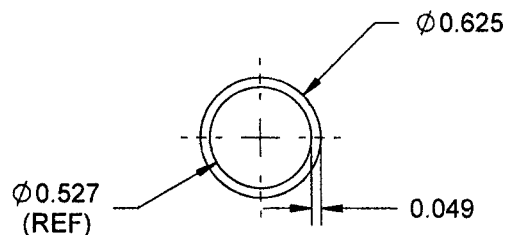
So yes we should keep them in stock.

Peter

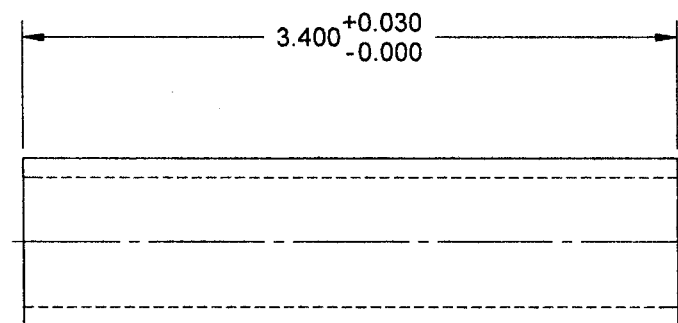
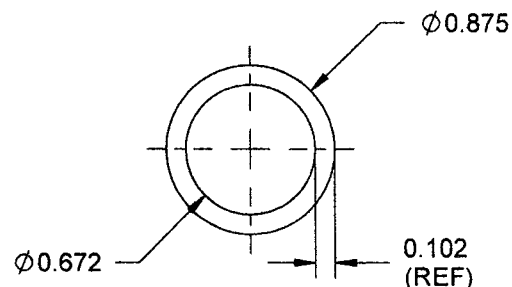
From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: February 7, 2008 9:00 AM
To: Peter Hum (Peter Hum)
Subject: D3662-1/-3

I have 18 of each crossbolt spacers on my desk D3662-1/-3 for the 117 skids. These are still under review, are they any good? Can I sign off the positive recall? Or do you want them upstairs? ?? ?? ??

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd



D3662-1 CROSS BOLT SPACER



W10
37189
01.02.08

D3662-3 CROSS BOLT SPACER

NOTES:

1) MATERIAL:

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TUBING PER WW-T-700/6 OR AMS 4080/4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART MATERIAL SPEC. M6061T6T0.625W0.49)

D3662-3 - ALUMINUM 6061-T6 (OR 6061-T651/T6510/T6511/T62)
ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART MATERIAL SPEC. M6061T6RX.XXX)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3662-1 - 0.03 LBS D3662-3 - 0.08 LBS

RELEASED
07.11.22

A	NEW ISSUE		PH
REV.	DESCRIPTION		BY
DESIGN	py	DART AEROSPACE USA, I PORT HADLOCK, WA	
DRAWN	py		
CHECKED	py	DRAWING NO.	
MFG. APPR.	py	D3662	
APPROVED	py	TITLE	
DE APPR.	py	CROSS BOLT SPACER	
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